

Work Order ID 74130

Friday, September 23, 2011 8:53:02 AM



Page 1

Item ID: D3646-3

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 9/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-09-23*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3646

Rev *B C*

E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959 *SP*

4 *FF* *12-02-02*

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- Bend as per dwg D3646 *SP*

4 *FF* *12-02-02*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/22/12

(X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/26/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

4X of M-12/02/03

H BL 12-23.

(H) SP 12-02-03.

MU 5128

9:30
3200F
10:00

ST 209

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Arm

Start Date: 9/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/26/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MCS 12/02/06

12/02/06
(H)

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Picklist Print

Friday, September 23, 2011 8:53:07 AM

Page 1

Work Order ID: 74130



Parent Item: D3646-3



Parent Item Name: Arm

Start Date: 9/23/2011

Required Date: 9/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	214.6323	2.91	12.25263			



304 RD Tube .500 x .035W



Sp 11/1/05

Location

Loc Qty

Loc Code

MAT017

214.6322723

115535

2.33

116720

1.66068

117598

34.6415923

118702

176

14

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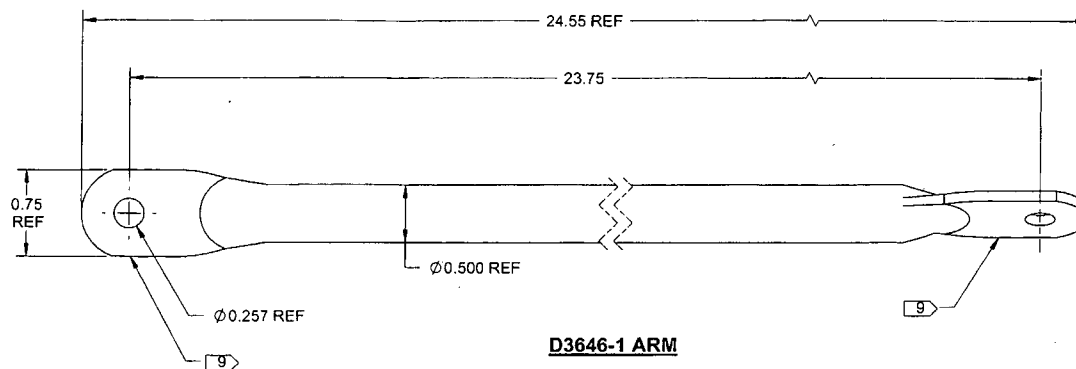
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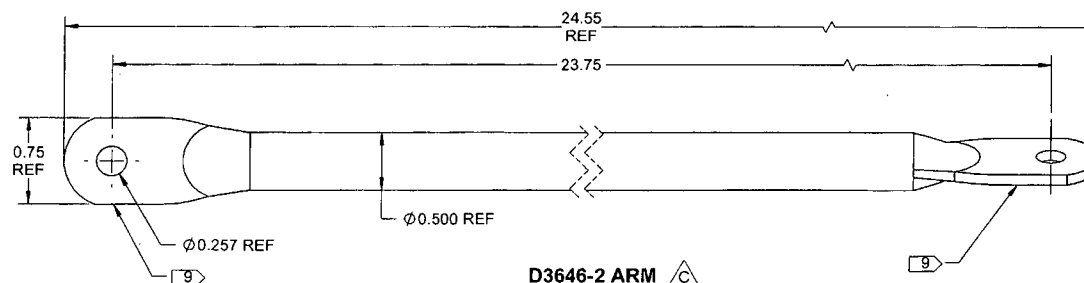
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74130

110923



D3646-1 ARM



D3646-2 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) DELETED AT REV. C
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

C	ADD-2 & -4 FOR LHS INSTALLATION. DELETE REFERENCES TO TEMPLATES (NOTE 8) PER SHOP REQUEST.	AJS	11.07.11
B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1). ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3646	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARM	NTS
DATE	11.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-07-13

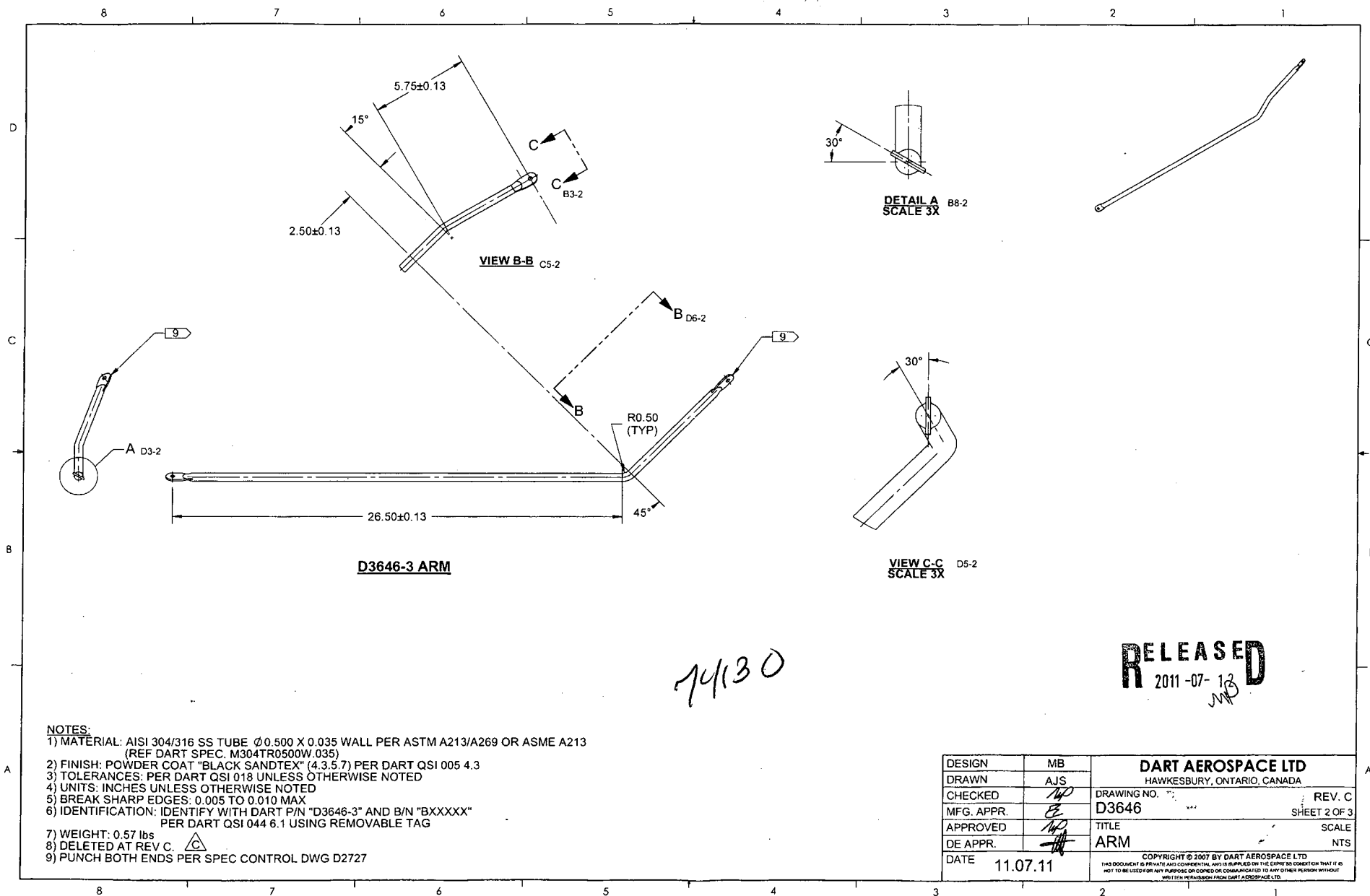
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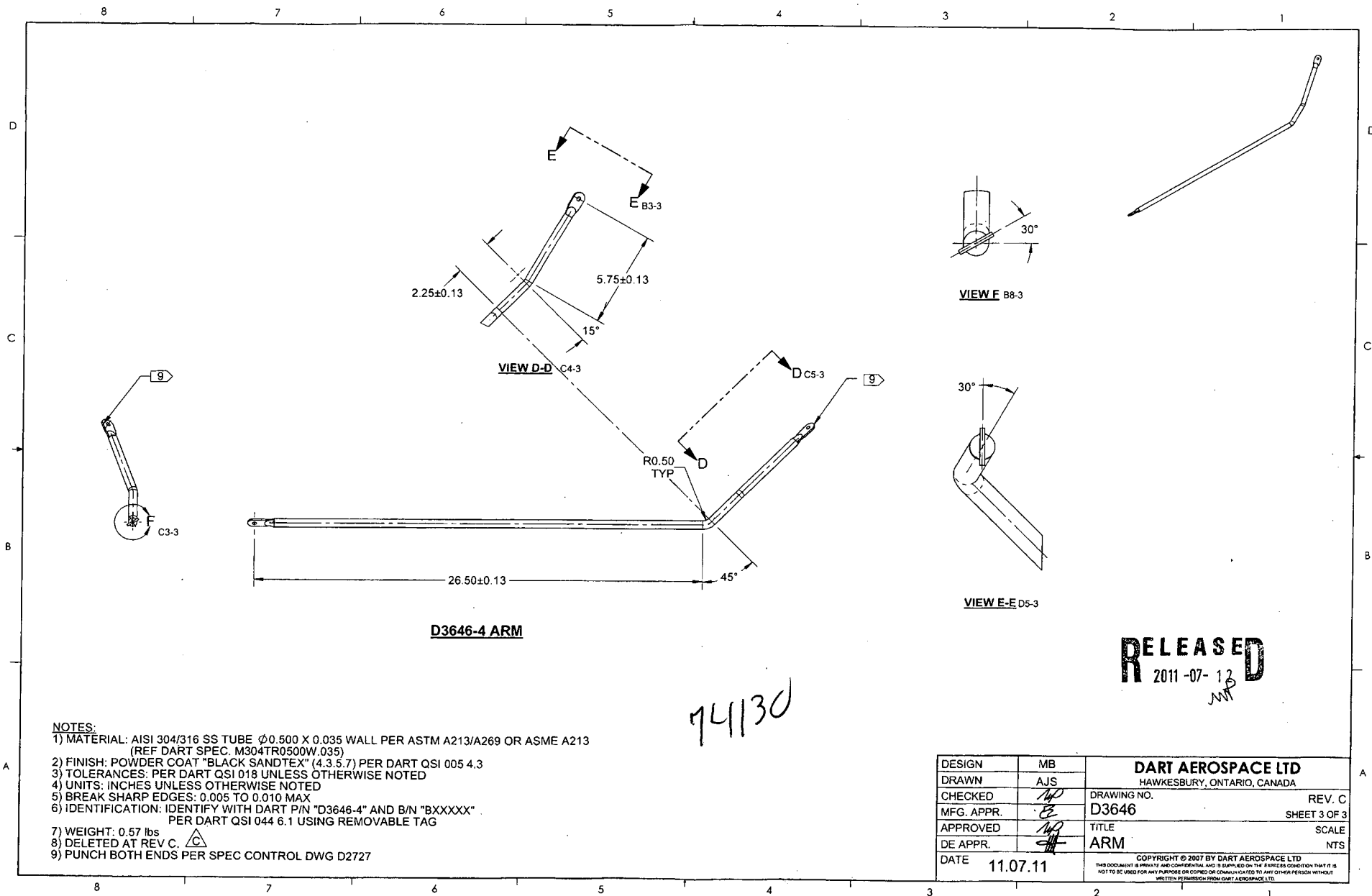
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